

Work Order ID 84337

84337

Page 1

Wednesday, May 09, 2012 4:35:20 PM

Item ID: D412-705-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Intake Plenum Access Panel

Start Date: 5/9/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 5/11/2012 Req'd Qty: 3.00

3

Customer:

Reference: ECN 12-560

Approvals: Process Plan: MF

Date: 12-05-09

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev C

150

0.00

150

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D412-705-013 X 3 B 80577

REMOVE D3245-043 AND BRING TO SMALL FAB

3

12/05/14

160

0.00

160

Small Fab

Memo

0.00

Small Fab

REMOVE OLD STUDS FROM D3245-043 AND REPLACE WITH NEW STUDS

PER NEW DRAWING D3245-043 REV C

ECN 12-560

6x

12/05/14

Put back stud in stock
23 51-20-009-C3y B 120595

Work Order ID 84337

84337

Page 2

Wednesday, May 09, 2012 4:35:20 PM

Item ID: D412-705-013 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Intake Plenum Access Panel
 Start Date: 5/9/2012 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 3.00 ***3*** Customer:
 Reference: ECN 12-560

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: Memo ID AND STOCK UNDER NEW BATCH NUMBER, CHANGE 003 PER ECN 12-560	0.00 0.00							
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Handwritten notes and stamps:

- Circle around 170
- Circle around 180
- Handwritten: 12/05/14
- Handwritten: MF
- Handwritten: 12-05-14

Picklist Print

Wednesday, May 09, 2012 4:35:19 PM

Page 1

Work Order ID: 84337

Parent Item: D412-705-013

Parent Item Name: Intake Plenum Access Panel

Start Date: 5/9/2012

Required Date: 5/11/2012

Start Qty: 3.00

Required Qty: 3.00

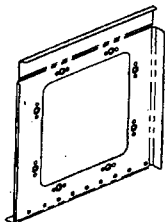
Comments: IPP Rev:A New Issue 07-09-09 JLM Verified By:EC
IPP Rev:B ECN 1052 07-11-05 DD Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
127H-35 HALF GROMMET		Purchased	No				Each	80.0000		24		5/12/05/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		72							
				119545		72			48				
				ST398		8							
				117203		5							
				118261		3							
2351-20-012-C3Y STUD		Purchased	No				Each	123.0000		24		5/12/05/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				399		100							
				121499		100			25				
				ST400		23							
				121237		23			23				

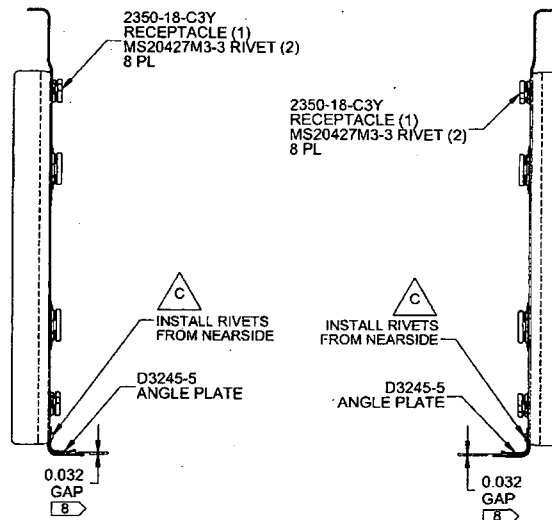
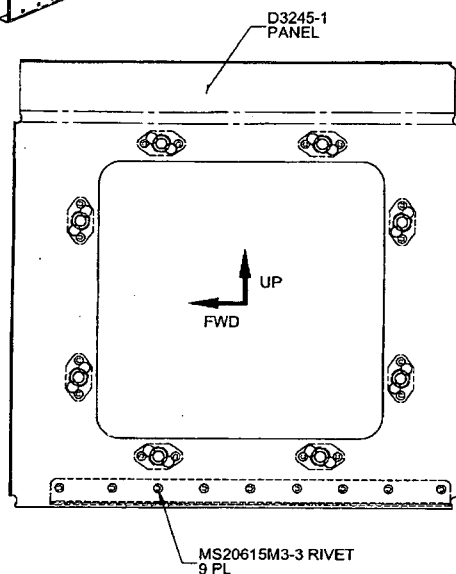
2351-20-009-C34

by

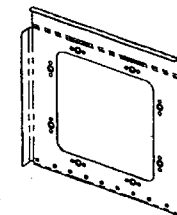
x - 72



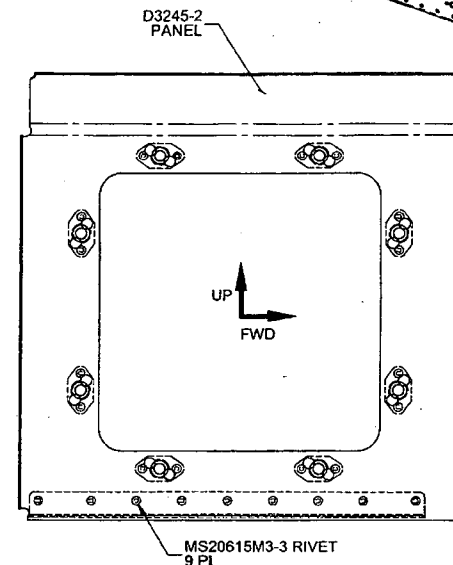
D3245-041 ACCESS PANEL ASSY (LH)



484337



D3245-042 ACCESS PANEL ASSY (RH)



RELEASED 2012-05-07

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
	1	D3245-2	PANEL
1		D3245-5	ANGLE PLATE
8		2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

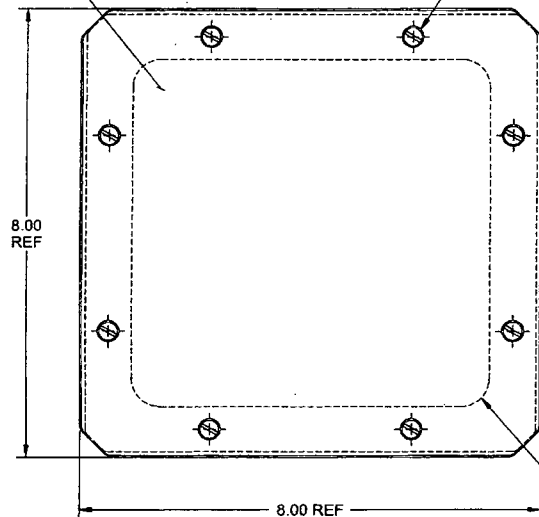
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A 0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C		ADDED NOTE 8, SHEET 1: SPECIFIED RIVET ORIENTATION (B4-1, B5-1). CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165		RP	12.04.11
B		REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS2108G-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	RF			DART AEROSPACE LTD	
DRAWN	MB			HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.			DRAWING NO.	REV. C
MFG. APPR.	[Signature]			D3245	SHEET 1 OF 7
APPROVED	[Signature]			TITLE	SCALE
DE APPR.	[Signature]			ACCESS PANEL ASSY	NTS
DATE	12.04.11			COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

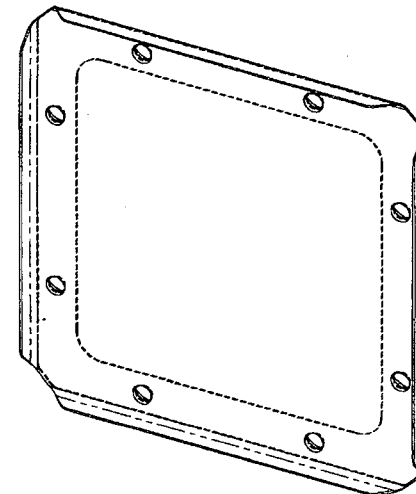
D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL



INSTALL D3245-7
GASKET ON THIS SIDE
6

D3245-7 GASKET
REF



D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

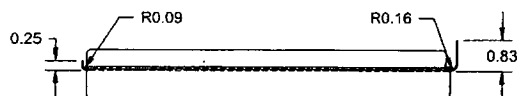
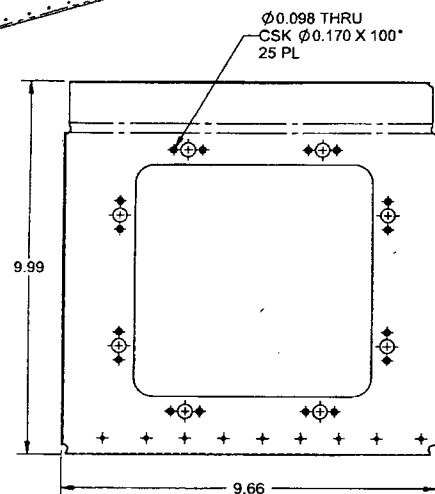
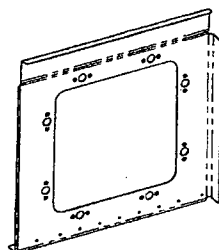
84337

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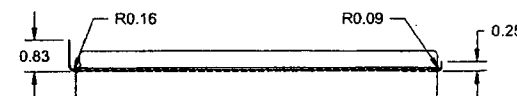
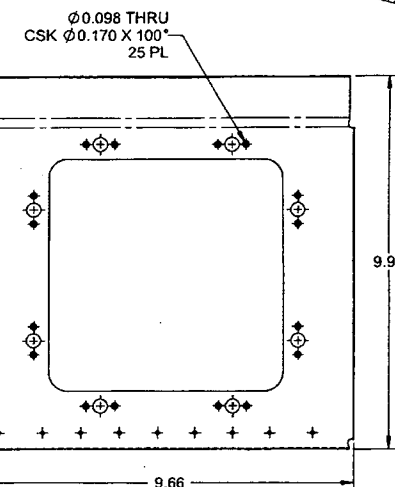
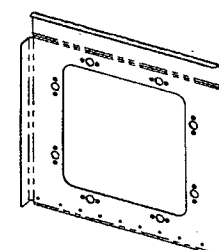
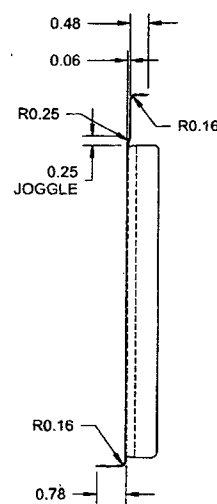
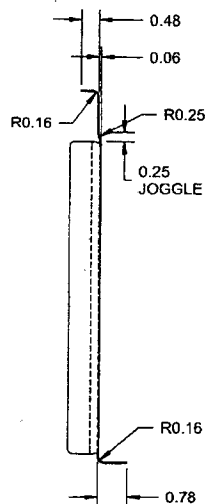
2012-05-07

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D3245	SHEET 2 OF 7
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ACCESS PANEL ASSY	
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8 7 6 5 4 3 2 1



D3245-1 PANEL (LH)



D3245-2 PANEL (RH)

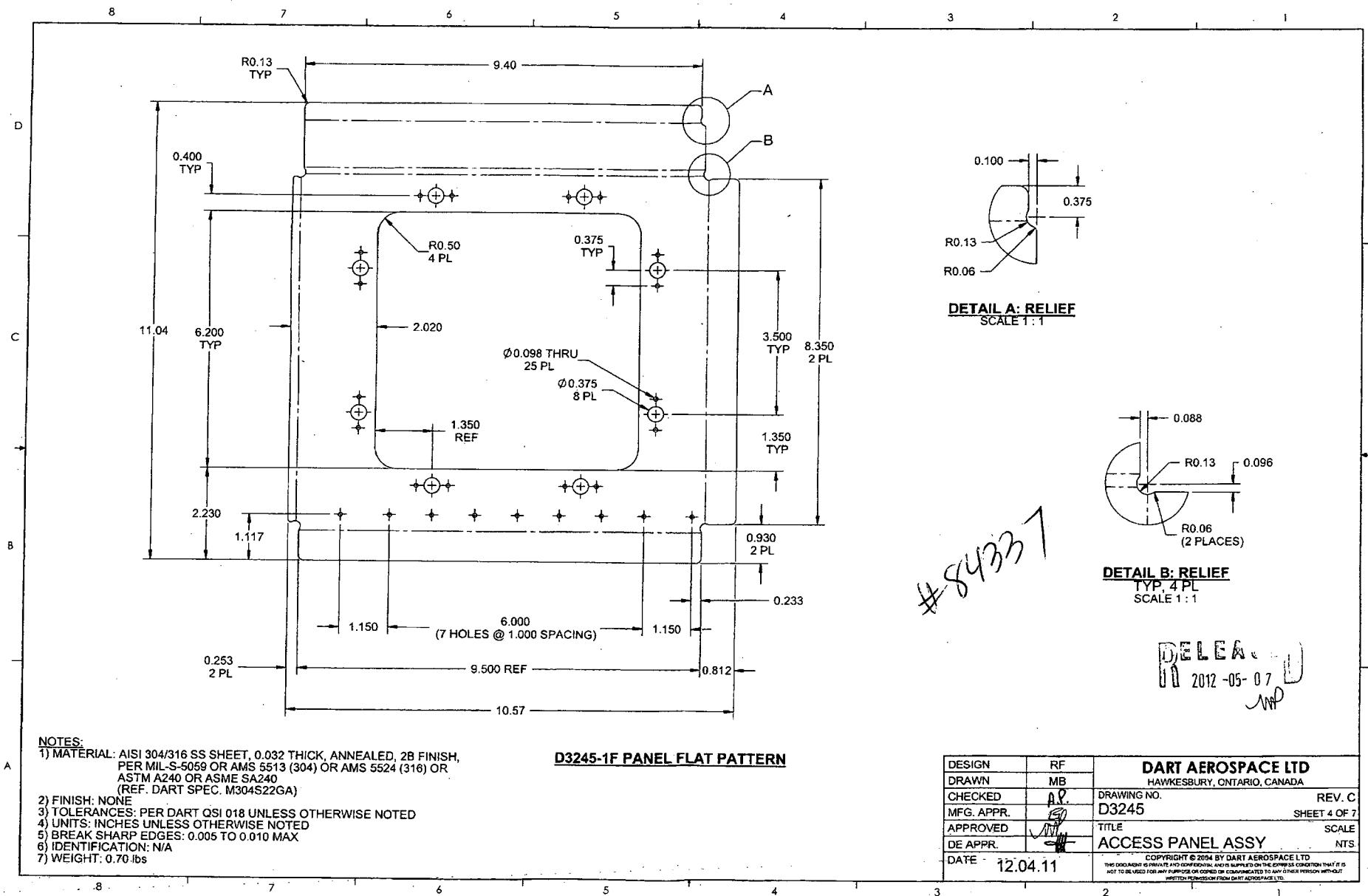
NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

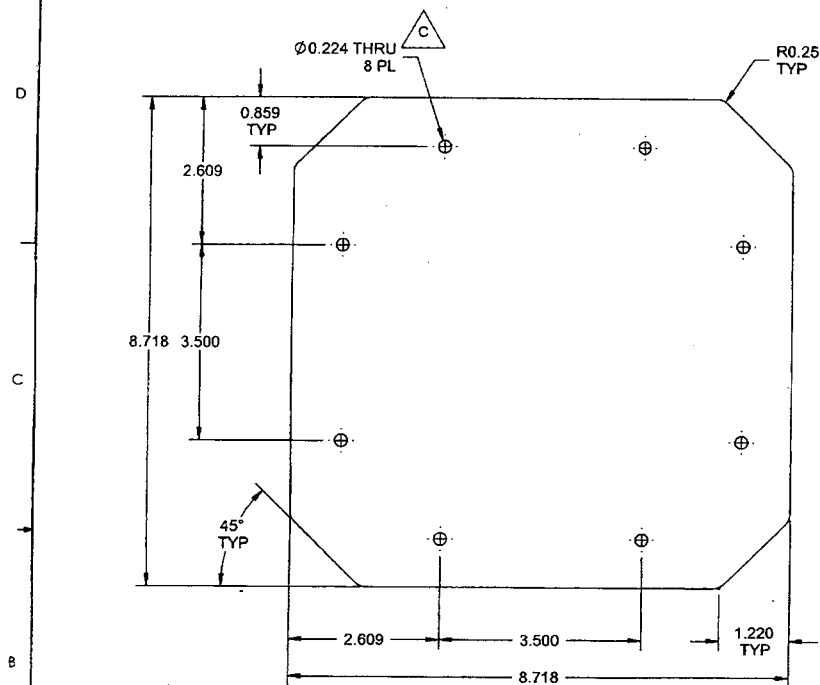
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2012-05-07

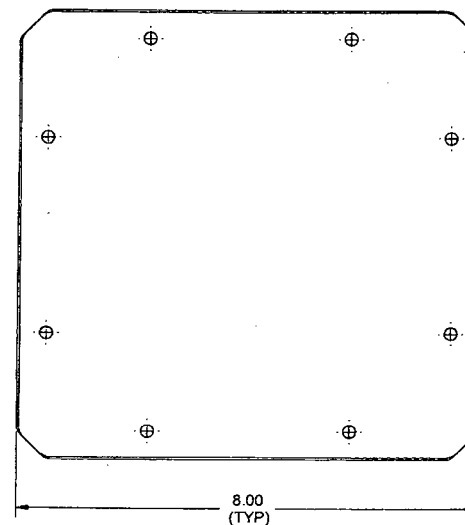
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DRAWN	MB		
CHECKED	A.P.	DRAWING NO. D3245	REV. C
MFG. APPR.			SHEET 3 OF 7
APPROVED		TITLE ACCESS PANEL ASSY	SCALE NTS
DE APPR.		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.04.11		



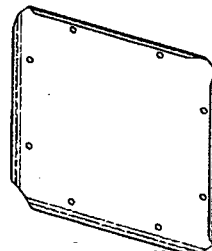
8 7 6 5 4 3 2 1



D3245-3F DOOR FLAT PATTERN



**D3245-3 DOOR
(MADE FROM D3245-3F)**



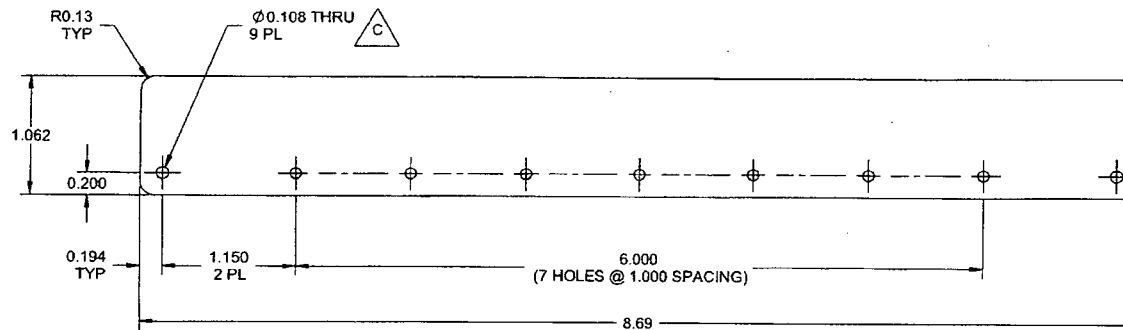
#84337
RELEASED
2012-05-07

NOTES:

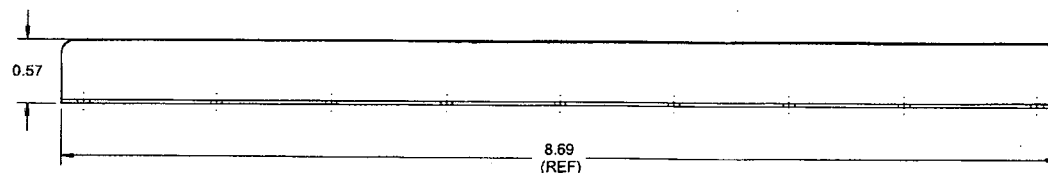
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.66 lbs

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DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	AP	D3245	SHEET 5 OF 7
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	ACCESS PANEL ASSY	NTS
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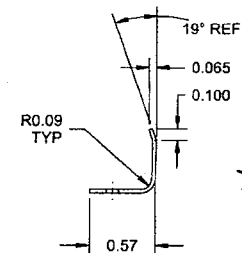
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D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



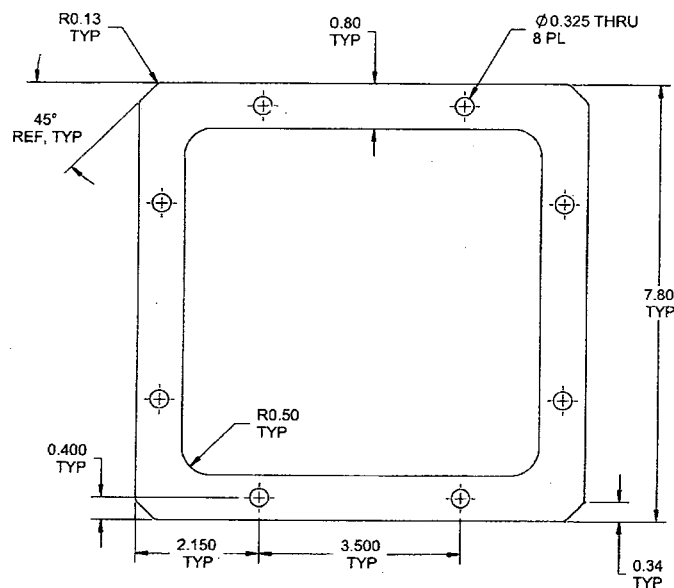
19° REF
0.065
0.100
#84337

RELEASED
2012-07-07

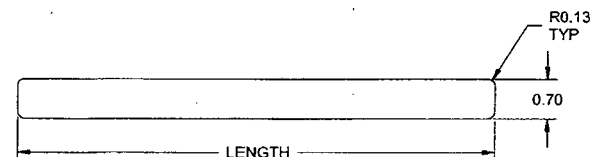
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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MFG. APPR.	FD	D3245	SHEET 6 OF 7
APPROVED	JAN	TITLE	SCALE
DE APPR.	JAN	ACCESS PANEL ASSY	NTS
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AV	DRAWING NO.	REV. C
MFG. APPR.	AV	D3245	SHEET 7 OF 7
APPROVED	AV	TITLE	SCALE
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DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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#84337

REV. C
2012-05-07

List Lots

Wednesday, May 09, 2012 4:27:58 PM

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Criteria : Item ID: D412-705-013 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D412-705-013 Intake Plenum Access Panel	Main Warehouse FG010	80577	4/4/2012	3.0000	QC21	CHG002	
Total:				3.0000			

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.04.11	Job No.:	ADR Yes/No: N	ADR Date:	ECN #: 12- 560
Product No.: D412-702, D412-705	Created By: RP	Approved By: <i>[Signature]</i>		
Product Name: Twin Pak E-Z Access Kit	Checked By: <i>[Signature]</i>			

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL <i>MF</i>	
Purchasing Coord.	Y	CL	
Production Engineering Coord.	Y	JL	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	N		
QC Coordinator	N		
Customer Technical Support	Y	MB	
Marketing	Y	SW	
Customer Order Processing	N		

Reason for Change: D3245-041 & D3245-042: Tighter tolerance required on 0.32 gap. D3245-043: Studs too short. D3307: One of the fasteners interferes with a fire extinguishing tube on the aircraft. IIN-D412-705: Impossible to plug one of the un-used holes with a rivet (as instructed)

Documents Affected: *new diff place*

D3245 Rev. C, D3307 Rev. B, IIN-D412-705 Rev. D, MDL-412-705 Rev. A

PARTS MUST COMPLY



PREVIOUS PARTS SATISFACTORY



#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	RP	Rev. A	12.05.08 <i>[Signature]</i>
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		12.05.08 <i>[Signature]</i>
11	Update Product Specification Files	Y	KJ		12.05.08 <i>[Signature]</i>
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.05.08 <i>[Signature]</i>
13	Update Document Record (DR)	N	RP		
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Update Parts / STC Database	N			
17	Update / Verify ARC Database	N			
18	Create / Update Change Record Form / Item Card Database	Y	KJ	(See Description/Action)	12.05.08 <i>[Signature]</i>
19	Create / Update PPP's	Y	KJ		12.05.08 <i>[Signature]</i>
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.05.08 <i>[Signature]</i>
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		12.05.08 <i>[Signature]</i>
24					

Description / Action:

D412-705-013 @ CHG 003 - 3 stk *Rework*
D412-705-021 @ CHG 002 *Rework*
#84337

Any D3307 or D3245 currently in stock or in progress to comply with this change.

Replace IIN for kits in stock or in progress.

Rework #84340
12-05-08

Rework D3245-043 x4 in stock
#84278
D3245-043 #82301 w/p updated.
12-05-08

ECN Verified & Complete:

Date:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries